Work Order ID 67527 -/



Page 1

Monday, Marc	ch 28, 2011 9:06:54 AM									
Item ID:	D3319-3		Accept				s	etup Sta	art	
Revision ID: Item Name:	Wearplate							Ste		
Start Date:	3/28/2011 Start Qty:	12.00		Cust Item I	D:					
Required Date	e: 3/31/2011 Req'd Qty	2.00		Customer:						
Reference:										
Approvals:	Process Plan:	Date://03-2	Tooling:	D	ate:		R		W/ZEWINE	
	QC:	Date:	SPC (Y/N):	D	ate:			St	ор	
Sequence ID/ Work Center	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D3319	Rev B									
100 Waterjet	FLOW WATER		0.00	,			B11-3	86-2		
FLOW CNC Water		ut as per Dwg D3319 Dwg R urr if necessary	ev: Prog Rev:	2-					0	
110	DESCRIPTION OF THE PROPERTY OF	rts off machine FAI/FAIB	0.00				BII-	3-20		
QC Quality Control	Mer	no	0.00							
120		rts - second check	0.00	ſ						
QC Quality Control	Mer	mo	0.00 Unloz/	78			410	/		

Dart Aerospace Ltd	Dart	Aeros	pace	Ltd
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W/O:			W	ORK ORDER CHANGES					
DATE	STEP	PROCE	EDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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									1 1574
Part No	:	PAR #:	Fault Cat	egory:N	CR: Yes	No DQA:		_ Date: _	
	Re	esolution:	Dispositi	on: Q	A: N/C CI	osed:		Date: _	
NCR:		WC	ORK OR	DER NON-CONFORMANC	CE (NCR)			
D.475	0755	Description of NC		Corrective Action Section B	464	Verificat	tion	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
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Work Order ID 67527

Monday, March 28, 2011 9:06:54 AM



Page 2

Item ID:

D3319-3

Accept

Setup Start

Stop



Revision ID:

Item Name:

Required Date: 3/31/2011

Wearplate 3/28/2011

Start Qty: 12.00

Req'd Qty: 12.00

Cust Item ID: Customer:

Tool ID

Reference:

Start Date:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start Run

Reject

Qty



Reject

QC:

Date:

SPC (Y/N):

Date:

Tool # Plan

Code

Stop

Number Stamp

Insp.

Sequence ID/ Work Center ID

130

Small Fab

Small Fab

Operation Description

Small Fab

Set Up/ Run Hours

0.00

0.00

Deburr if necessary

140

Brake NC

Brake NC

NC BRAKE

Memo

Memo

0.00

0.00

Form using DT8326 & DT8261 as per Dwg D3319Rev

Accept

Qty

150

Quality Control

QC6- Inspect dimensions to drawing

Memo

Dart Aerospace Ltd

W/O:			WO	RK ORDER CHANGES	3			
DATE	STEP	PRO	CEDURE CHAI	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date: _	
	Res	solution:	Disposition	1:	QA: N/C CI	osed:	Date: _	
NCR:		V	VORK ORDI	ER NON-CONFORMAN	ICE (NCR)		
		Description of NC		Corrective Action Section		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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Work Order ID 67527

Monday, March 28, 2011 9:06:54 AM



Page 3

Item ID:

D3319-3

Accept



Setup Start

Stop



Revision ID:

Item Name:

Wearplate

Start Date:

3/28/2011

Start Qty: 12.00

Req'd Qty: 12.00



Cust Item ID:

Customer:

Tool ID

Reference: Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop



Stamp

Required Date: 3/31/2011

QC:

Date:

SPC (Y/N):

Date:

Code

Qty

Tool# Plan

Reject Accept

Qty

EZ 11-4-5

Reject Insp.

Number

Work Center ID

160

Sequence ID/

Large Fab

Large Fab

Operation Description

Large Fab

Set Up/ Run Hours

0.00

0.00

Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319 Rev: Part Number Description Batch □ A/R

170

Quality Control

QC10- Inspect visual per QSI004- ground welds

QC5- Inspect part completeness to step on W/O

0.00 Dulo4/06

0.00

8 worlos

180

Quality Control

Memo

Memo

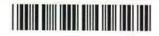
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	-7								
Part No	:	PAR #:	Fault Categ	gory:	_ NCR: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Disposition	n:	QA: N/C C	osed:		_ Date: _	
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		Description of NC			tion B	Verifi	cation	Approval	Approval
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Work Order ID 67527

Monday, March 28, 2011 9:06:54 AM



Page 4

Item ID:

D3319-3

Accept

Setup Start

Stop

Revision ID:

Start Date:

Item Name: Wearplate

Required Date: 3/31/2011

3/28/2011

Start Qty: 12.00

Req'd Qty: 12.00

Cust Item ID: Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



OC:

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Tool # Plan

Code

Stop

Sequence ID/ Work Center ID

190

Powdercoat

Powder Coating

Operation Description

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

M 115178

Memo FINISH TIME:

0.00

0.00

OVEN TEMPERATURE:

200

OC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

210

Packaging

Packaging

Packaging

Memo

0.00

0.00

Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3319-3, B/N: BXXXXX For Product Eligibility see PDA05-18 and

Stock Location:

Qty

Accept

Qty

Reject

Reject Insp. Number Stamp

Bl 17-4-6.

Dart	Aeros	pace	Ltd
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W/O:			WO	RK ORDER CHANGE	S			
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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Work Order ID 67527

Monday, March 28, 2011 9:06:54 AM



Page 5

Item ID:

D3319-3

Accept

Setup

Start

Stop



Revision ID:

Item Name:

Required Date: 3/31/2011

Wearplate

3/28/2011

Start Qty: 12.00 Req'd Qty: 12.00

Cust Item ID: Customer:

Tool ID

Reference:

Start Date:

Approvals:

Process Plan:

Operation

Description

Date:

Tooling:

Date:

Run

Accept

Qty

Start

QC:

Date:

SPC (Y/N):

Set Up/

Date:

Tool # Plan

Code

Stop

Sequence ID/

Work Center ID

220

QC21- Final Inspection - Work Order Release

Memo

Run Hours

0.00

Reject Qty

Reject Number

Insp.

Stamp

Quality Control

0.00

Dart Aerospace Ltd	Dart	Aeros	pace	Ltd
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W/O:			WO	RK ORDER CHANG	ES			
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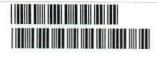
Picklist Print

Monday, March 28, 2011 9:07:00 AM

Work Order ID: 67527

D3319-3 Parent Item:

Parent Item Name: Wearplate



Start Date: 3/28/2011

Required Date: 3/31/2011

Page 1

Start Qty: 12.00 Required Qty: 12.00

Comments:

IPP: A□05.05.12□New issue□KJ/JLM□

IPP Rev:B Now on Waterjet 06-10-03 JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S18GA		Purchased	No			100	sf	120.0000	3.2524	41.08295			
TOTAL CONTRACT OF										HBI	1-3-09	в	

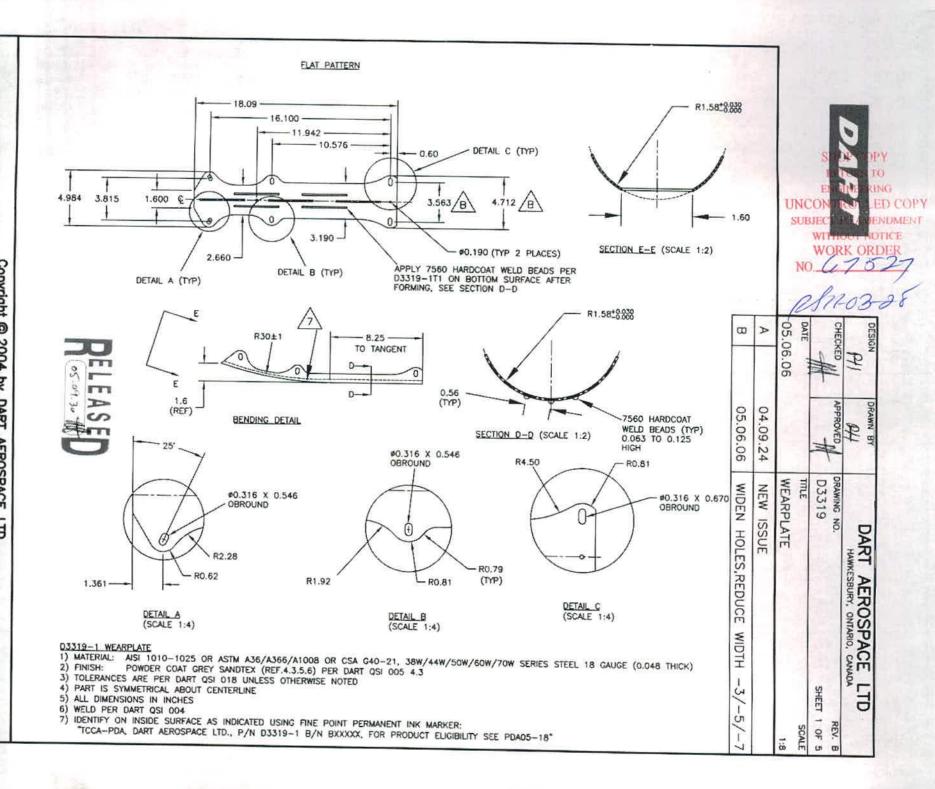
1010/1025 SHEET .048

Location Loc Qty Loc Code MAT019 120 116268 120



Dart Aerospace Ltd WORK ORDER CHANGES W/O: Approval Approval PROCEDURE CHANGE By Qty Chief Eng / DATE STEP Date QC Inspector Prod Mgr Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: ____ Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____ WORK ORDER NON-CONFORMANCE (NCR) NCR: Corrective Action Section B Description of NC Verification Approval Approval DATE STEP Initial Action Description Sign & Section C Chief Fng OC Inspector

	Section A	Chief Eng	Chief Eng	Date	Section C	Office Eng	QC Inspector



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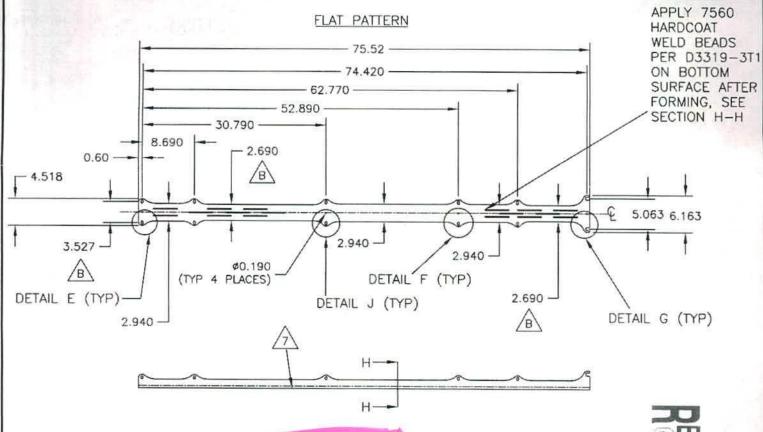
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DATE	STEP	PROC	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	_ Fault Cat	tegory:	_ NCR: Yes	No DQ	A:	_ Date: _	F
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DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	on B Sign Date	& Sec	cation tion C	Approval Chief Eng	Approval QC Inspector
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REV.

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BENDING DETAIL

D3319-3 WEARPLATE

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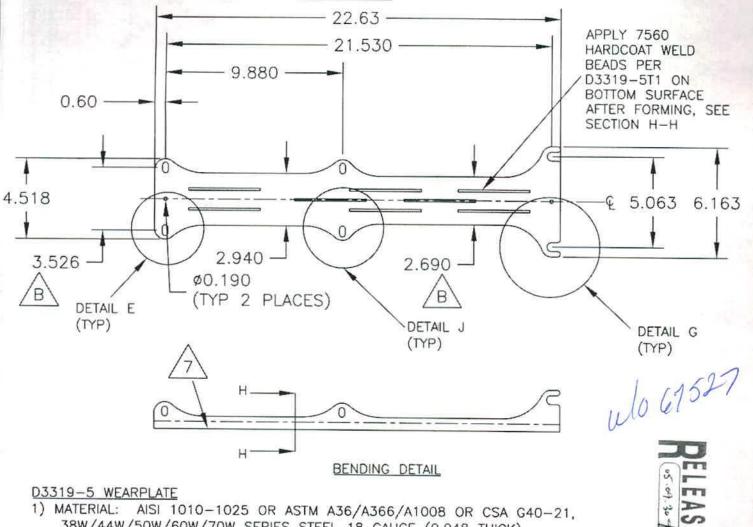
98 COPIED

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX. FOR PRODUCT ELIGIBILITY SEE PDA05-18"

Dart	Aerospace	Ltd
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W/O:			WO	RK ORDER CHANGE	S			
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		Description of NC		Corrective Action Section B			Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	QC Inspector
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FLAT PATTERN

- 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004

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PURPOSE

7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX. FOR PRODUCT ELIGIBILITY SEE PDA05-18"

Dart A	erospace	Ltd
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W/O:			WORK ORDER	CHANGES				
DATE	STEP	PROCEDU	RE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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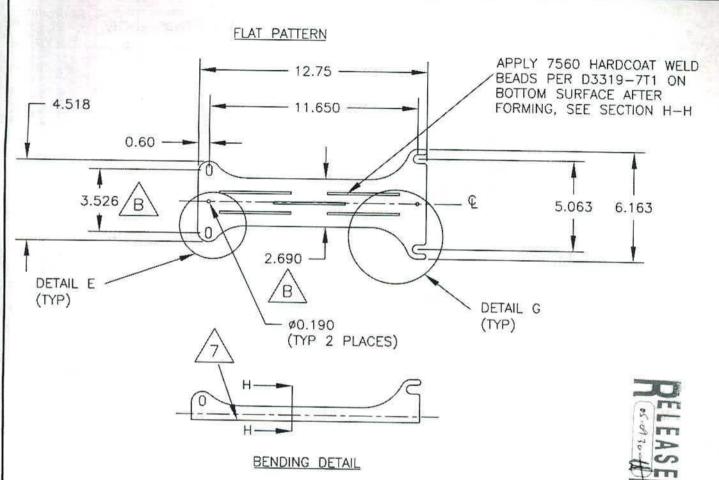
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DATE	STEP	Section A		itial ief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector

05.06.06 Ŧ P D3319 WEARPLATE AEROSPACE SBURY, ONTARIO, CANA

SHEET

OF 5

w/o 41527



D3319-7 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

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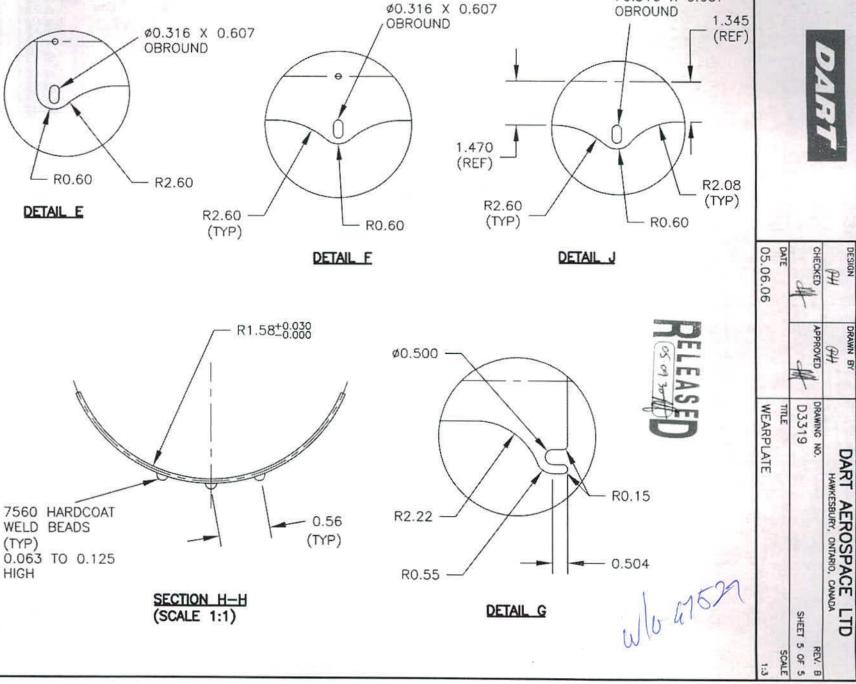
PURPOSE

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W/O:			V	VORK ORDER CHANG	ES			
DATE	STEP	PRO	OCEDURE CH	IANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Ca	tegory:	_ NCR: Yes	lo DQA:	Date: _	
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DATE	STEP	Description of NC			tion B	Verification	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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W/O:			WO	RK ORDER CHANG	ES			
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Part No	:	PAR #:	Fault Cate	jory:	NCR: Yes	No DQA:	Date: _	
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	1000
Description: Wearplate	Part Number:	D3319-3
Inspection Dwg: D3319 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article	Prototype
- 5.5		

75.52 74.420 62.770 52.890	+/-0.030	75.50			Inspection	Comments
62.770	./ 0 040	13.30	*		7 1801	
to reconstruction	+/-0.010	74.470	b		T	
52.890	+/-0.010	67.70	1		7	
	+/-0.010	52.890	1		1	
30.790	+/-0.010	30,740	+		7	
8.690	+/-0.010	8.690	+		7	
0.60	+/-0.030	,604	R		V 1802	
2.690	+/-0.010	2,700	}		V	
2.940	+/-0.010	2.946	Þ		V	
3.527	+/-0.010	3,508	+		V	
4.518	+/-0.010	4.519	80		V	
Ø0.190	+0.005/-0.001	091,	X 0	_	1	
2.940	+/-0.010	2.944	×		V	
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2.690	+/-0.010	2.693	×		V	
5.063	+/-0.010	5.062	٧		V	
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Measured by:	IB	Audited by:	Prototype Approval:	N/A
Date:	11-3-29	Date: 11/03/20	Date:	N/A

Rev		Change	Revised by	Approved
Α	07.07.18	New Issue	Revised by KJ/JLM	E
/ 1	107.07.10	New Issue	KOIDLIVI ON	u

Dart Aeros	pace Ltd
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W/O:			WO	RK ORDER CH	ANGES					
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:		PAR #:	Fault Cate	gory:	N	CR: Yes	No DQ	A:	_ Date: _	
Resolution:			Disposition:		Q	QA: N/C Closed: Date:				
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DATE	STEP	Section A	Corrective Action		Section B		Verific	Verification	Approval	Approval
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